

Work Order ID 62461

Thursday, September 30, 2010 12:43:27 PM



Page 1

Item ID: D3535-35

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 9/30/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 10/8/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

M

Date:

10-9-30

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3535

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

304 . 040

FB 10-10-5

(B)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

FB 10-10-5 Pro →

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Siolololol

(+12) (N)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3535-35 PAR #: W/S Fault Category: Sm. Fab. NCR: Yes No DQA: Alt Date: 10.10.26
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Alt Date: 10/10/26

NCR: <u>62461</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/10/26	#170	Found at inspection that Qty 1 part has 1 .300 x .300 hole cut wrong R. Part moved down	/WS/10/26	→ Scrap & Destroy qty 1 no replace extras were made.	AB 10-10-26	S 10/10/26	/WS/10/26	S 10/10/26
10/10/26	#110	R. Part moved / lifted during waterjetting process	/WS/10/26	/	/	/	/	S 10/10/26

NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, September 30, 2010 12:43:31 PM

Page 1

Work Order ID: 62461



Parent Item: D3535-35



Parent Item Name: Wearshoe


Start Date: 9/30/2010

Required Date: 10/8/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA  304/316 .040 Sheet		Purchased	No			100	sf	122.8987	0.8022	6.755368			



810-10-5

Location

Loc Qty

Loc Code

MAT

100.1522

114574

10.6522

115762

89.5

MAT20

22.7465

112885

2.7475

113062

0.699

115440

19.3

115762

13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	64264
Description: Wearshoe		Part Number:	D3535-35
Inspection Dwg: D3535	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.000	+/-0.010	2.000	*		V B02	
1.885	+/-0.010	1.889	*		V	
6.00	+/-0.030	6.000	*		V	
6.75	+/-0.030	6.749	*		V	
Ø0.188	+0.005/-0.001	.188	*		V	
23.250	+/-0.010	23.250	*		T B01	
19.750	+/-0.010	19.750	*		T	
17.750	+/-0.010	17.750	*		T	
14.250	+/-0.010	14.250	0		T	
9.500	+/-0.010	9.500	*		T	
4.750	+/-0.010	4.750	*		T	
0.300	+/-0.010	.300	*		V	
0.300	+/-0.010	.300	*		V	
0.038	+/-0.010	.037	*		V	

Measured by: JB	Audited by: S	Prototype Approval:	N/A
Date: 10-10-5	Date: 10/10/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	BE

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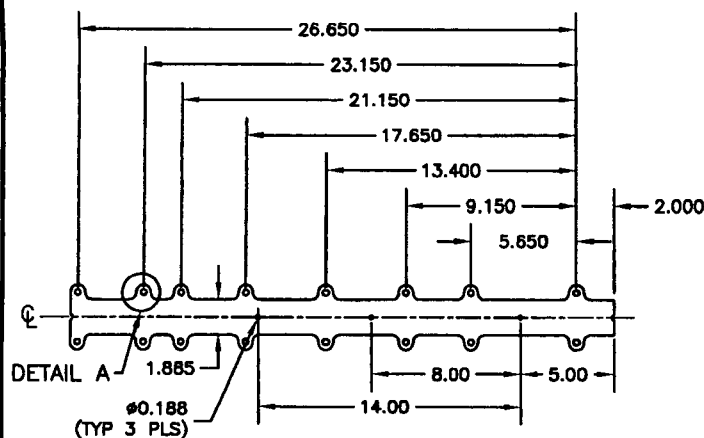
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DART

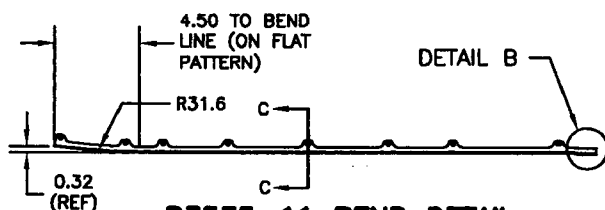
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07.04.24

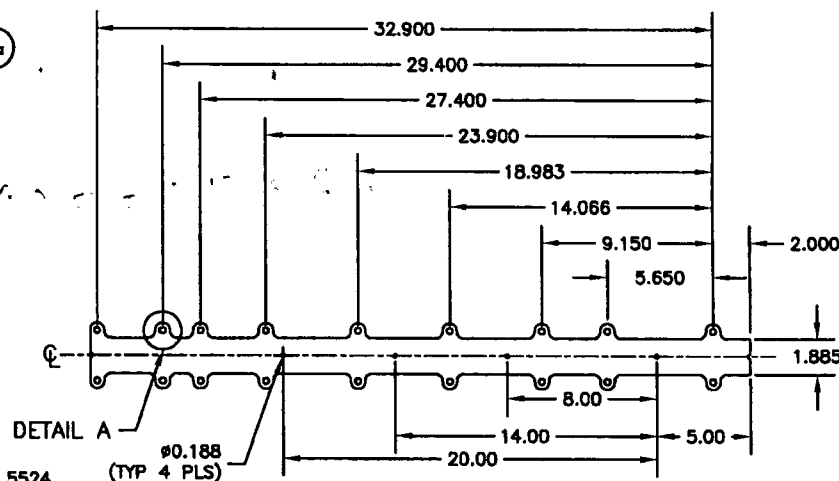
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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 6246
28109-30



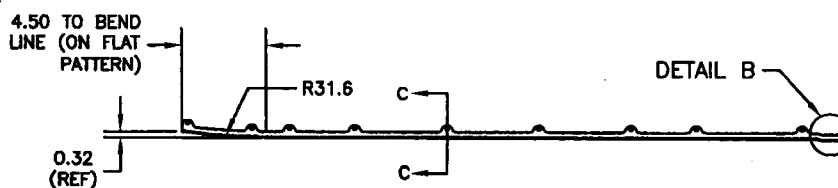
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.		
CB	PH	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. B	
#	#	D3535	SHEET 1 OF 7	
DATE		TITLE	SCALE	
07.04.17		WEARSHOE	1:10	
A	06.10.25	NEW ISSUE		
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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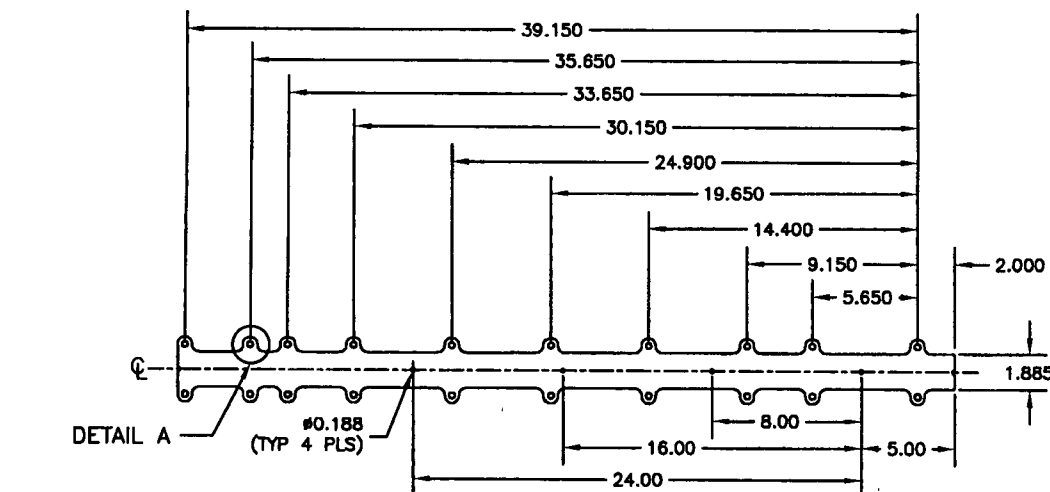
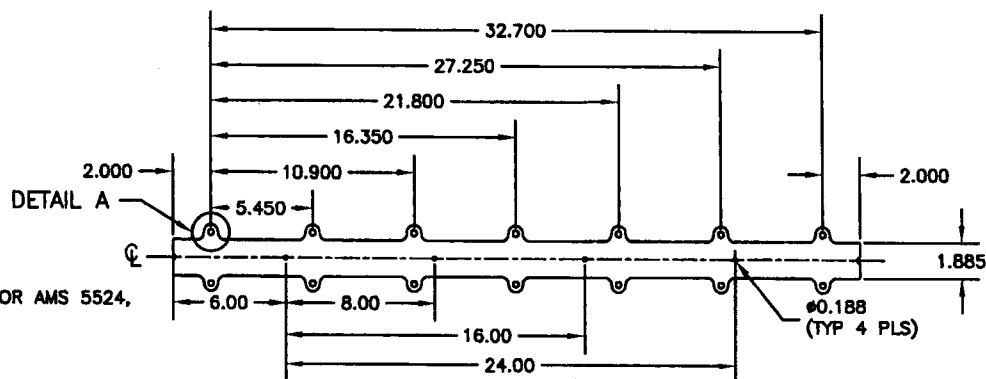
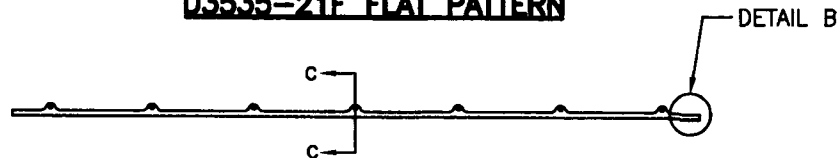
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CHECKED	APPROVED	DRAWING NO.	REV. B
#	#	D3535	SHEET 2 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	

**D3535-15F FLAT PATTERN**4.50 TO BEND
LINE (ON FLAT
PATTERN)**D3535-15 BEND DETAIL****D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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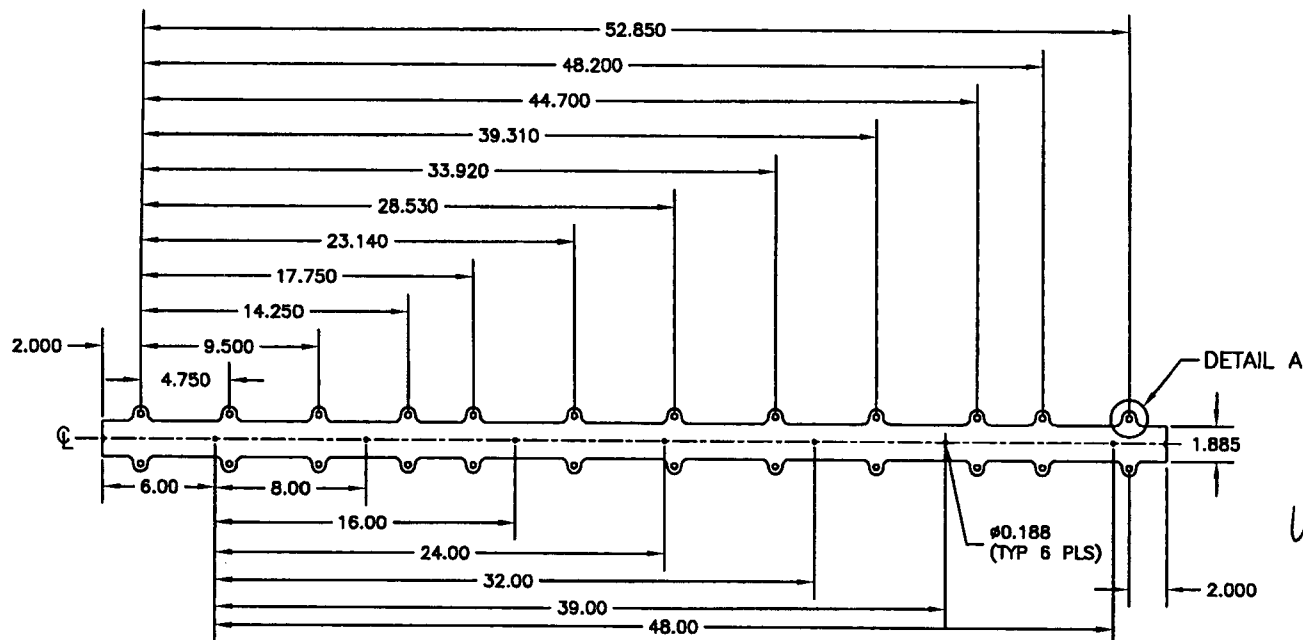
DART

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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	WEARSHOE
		SCALE	1:10	
		SHEET	3 OF 7	
		REV.	B	

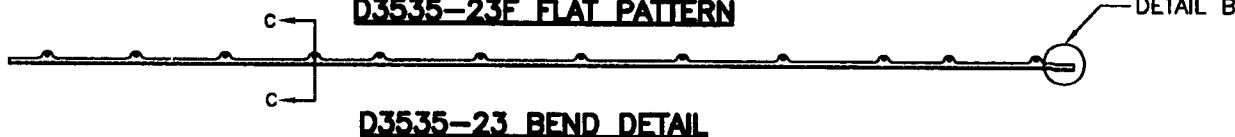
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07-04-24

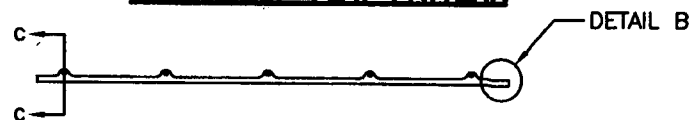
WLB 62461



D3535-23F FLAT PATTERN



D3535-25F FLAT PATTERN



D3535-25 BEND DETAIL

NOTES

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Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

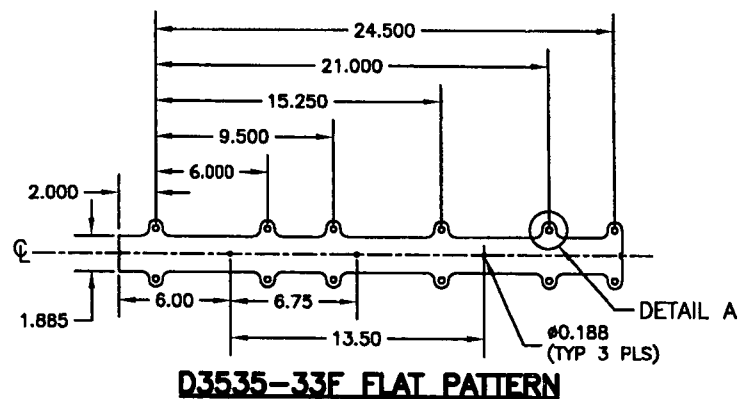
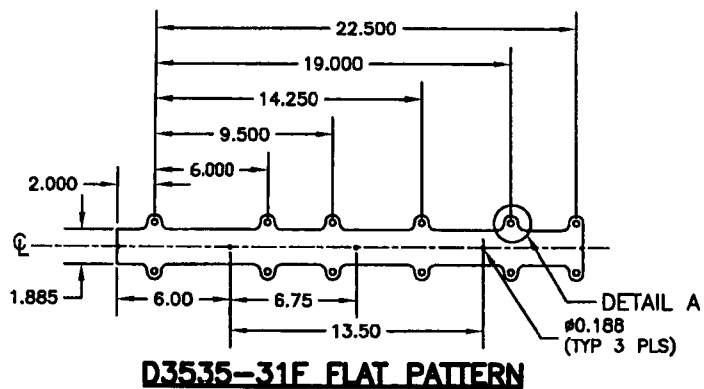
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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07.04.24



w/o 42461

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CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3535	
DATE	TITLE	SHEET 4 OF 7	
07.04.17	WEARSHOE	SCALE	
		1:10	

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
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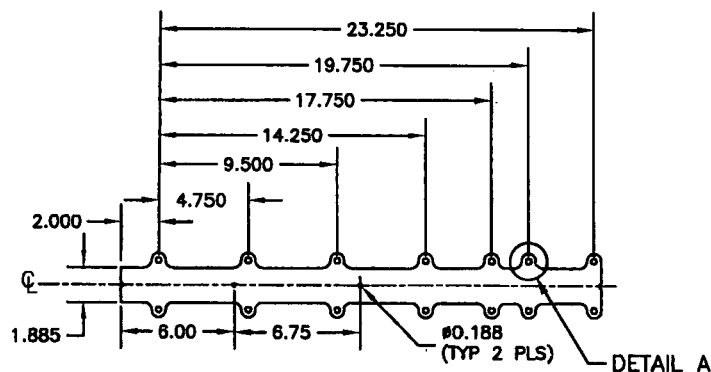
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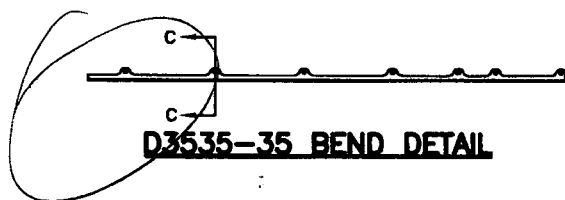
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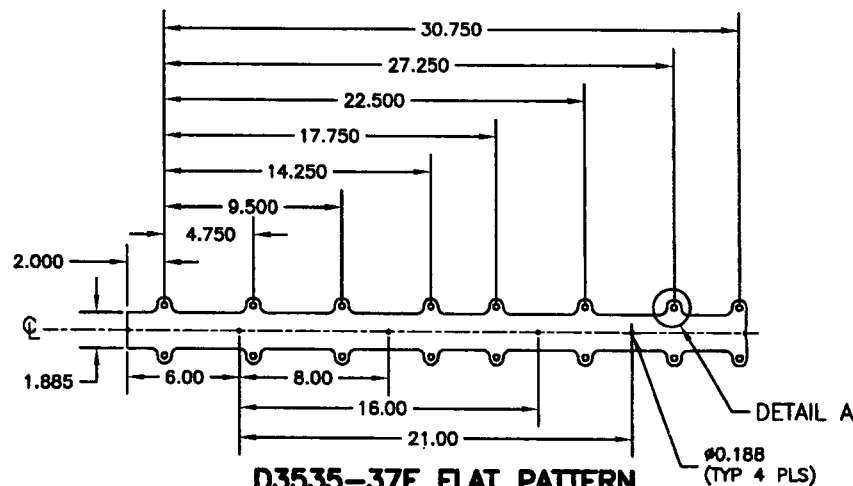
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	TITLE	WEARSHOE	REV. B
				SHEET 5 OF 7
				SCALE 1:10



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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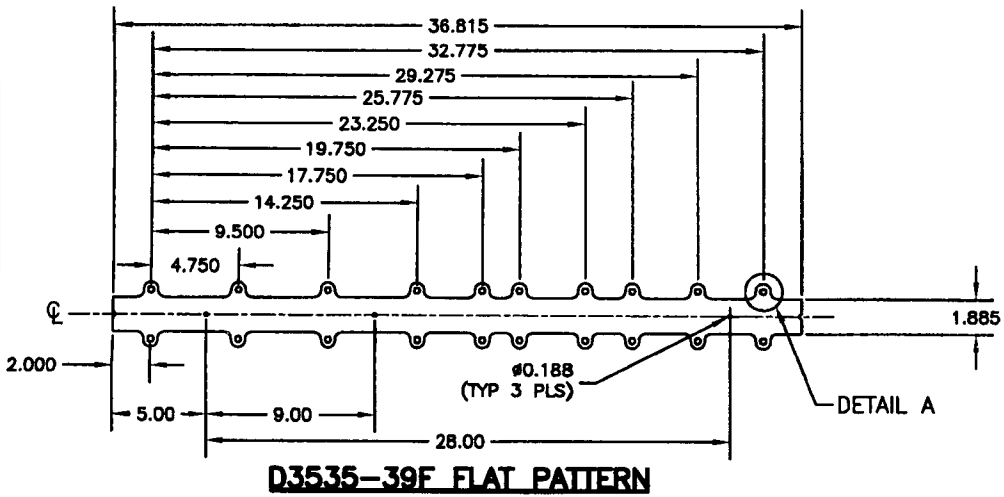
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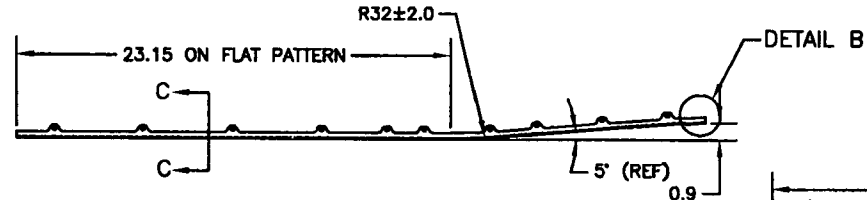
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who 42461

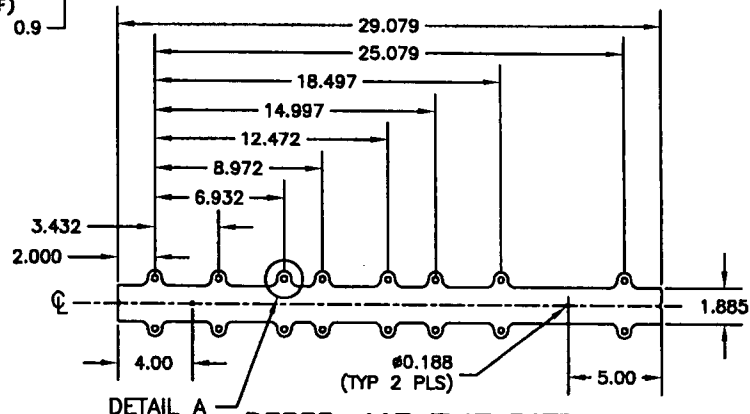
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CHECKED	APPROVED	DRAWING NO.	SHEET 6 OF 7
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DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	



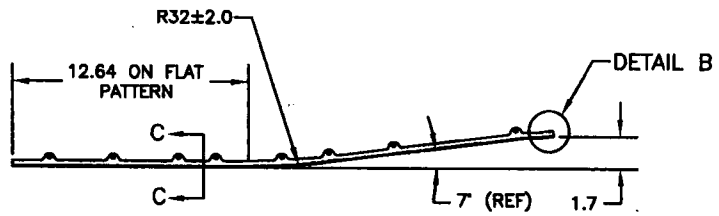
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

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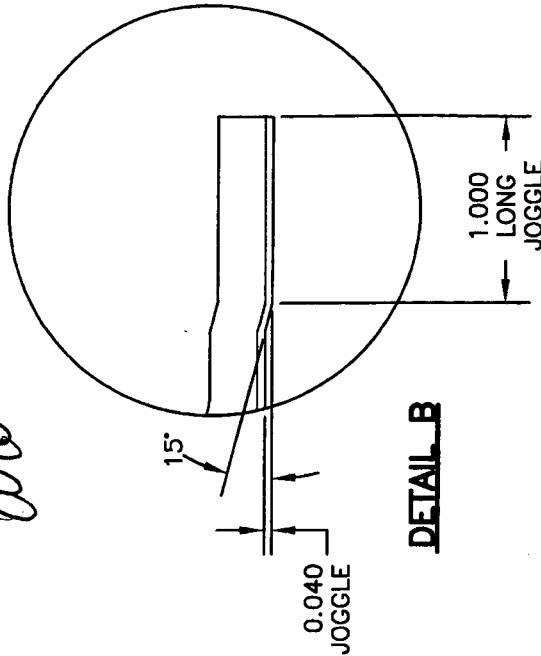


DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

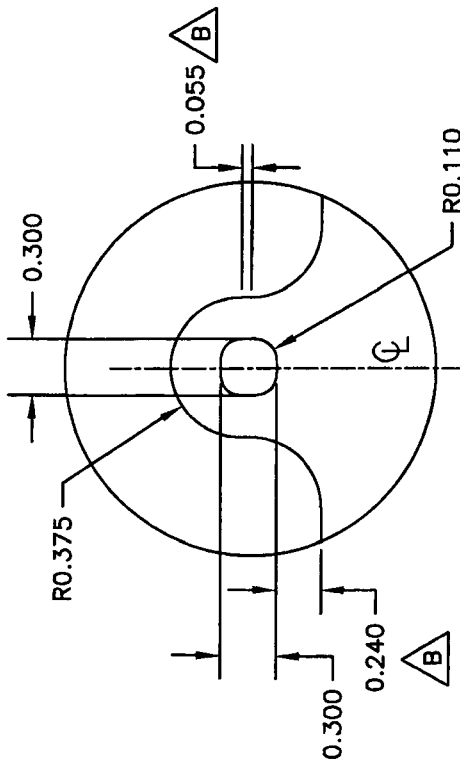
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07.04.24

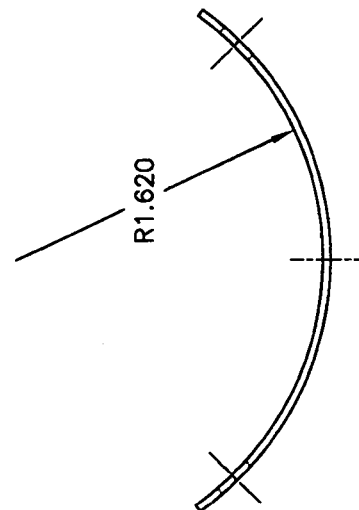
wb
6244



DETAIL B



DETAIL A



SECTION C-C

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